

5/16

4 8255

DART AEROSPACE LTD	Work Order:	22837
Description: Bracket Assembly	Part Number:	D3121-041
04.08.23 QC2 04.02.11 if IP 04.08.23		
Dwg: D3121 Rev. B page 1, 3, 4	Qty:	4 Kits
D3121-041 replaces Premier P/N B30-23000-33		
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveler <i>DWG NOT REGD</i>	KD	05/03/28	4																
2	MV	Cut blank: (1.00" x 2.00") x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: <i>M14773</i>	<i>5</i> CN	05/05/28	4																
3	MV	Machine D3121-11 as per Folio FA331 and Dwg D3121	<i>SD</i>	05.05.31	4																
4	QC2	Inspect parts as they come off the CNC machine	<i>SD</i>	05.05.31	4																
5	MV	Deburr Break all sharp edges 0.005 to 0.015	<i>SD</i>	05.05.31	4																
6	MV	Scribe batch number to D3121-11 at the back face.	<i>SD</i>	05.05.31	4																
7	QC5	Second check D3121-11	<i>SD</i>	05.05.31	4																
8	GA	Assemble D3121-041 as per Dwg D3121 Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3121-1121</td><td>Washer Bolt.</td><td><i>21881A</i></td></tr><tr><td>1</td><td>D3121-1124</td><td>Bearing ASE.</td><td><i>21855</i></td></tr><tr><td>1</td><td>MS24694-650</td><td>Screw</td><td></td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3121- 1121	Washer Bolt.	<i>21881A</i>	1	D3121- 1124	Bearing ASE.	<i>21855</i>	1	MS24694-650	Screw		<i>SD</i>	05.05.31	4
Qty	Part Number	Description	Batch																		
1	D3121- 1121	Washer Bolt.	<i>21881A</i>																		
1	D3121- 1124	Bearing ASE.	<i>21855</i>																		
1	MS24694-650	Screw																			
9	QC5	Inspect work to Step 8	<i>SD</i>	05.05.31	4																
10	ST	Identify and Stock in Spacedoor cell	<i>CL</i>	05/05/31	4																
11	AC	Cost / part <i>97.73</i>	<i>545</i>	05.06.01	4																
12	DC	Close W/O <i>128.07</i> Inspect Level 21	<i>4</i>	05.06.06	4																

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF RF	

RELEASED
03.05.06 RF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-05-31	8	Permanent Change. as shown.	<i>[Signature]</i>	05.06.31	N/A	<i>[Signature]</i> p. 05/06/02	<i>[Signature]</i> 05/06/03	

NCR: 22837		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-31	3	2x Blanks SCRAP DUE TO WRONG RAD (operator error).	<i>[Signature]</i> p. 05/06/02	SCRAP: Destroy PARTS	<i>[Signature]</i>	<i>[Signature]</i> 05-06-03	<i>[Signature]</i> p. 05/06/02	<i>[Signature]</i> 05-06-02

Part No: _____

PAR #: _____

Fault Category: Prod / machineNCR: Yes NoDQA: *[Signature]*Date: 05/06/03

NOTE: Date & initial all entries

QA: N/C Closed: *[Signature]*Date: 05.06.06

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 24, 2005
08:41 am

Work Order No : 0022837
Project Name : D3121-041
Project For : WK516
Work Order Type : Main
Main WO Number :
House Part Number : D3121-041
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 03-23-05
Est Finish Date : 04-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00	0.00	0.00
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00	0.00	0.00
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00	0.00	0.00
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00	0.00	0.00
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00	0.00	0.00
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00	0.00	0.00
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

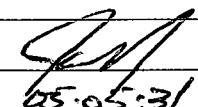
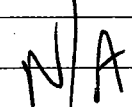
	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.58	+/-0.10					
.300	+/-0.10	.293	✓			
1.96	+/-0.020	1.965	✓			
.75	+/-0.030	.753	✓			
Ø.392	+0.002 -0.000	Ø.392	✓			
Ø.201 x .100p	Ø.201 +0.005 -0.000	Ø.201	✓			
.100dp	+/-0.010	.104	✓			
Ø.573	+/-0.010 +/-0.010	.568	✓			
.080	+/-0.010	.087	✓			
.300	+/-0.010	.310	✓			
2.56	+/-0.020	2.580	✓			
2.14	+/-0.020	2.145	✓			
2.85	+/-0.020	2.843	✓			
.130	+/-0.010	.132	✓			
.201	+/-0.010	.202	✓			
.400	+/-0.010	.401	✓			
.580	+/-0.010	.570	✓			
.381	.381 +0.005 -0.000	.375	✓			
R.250	+/-0.010					

Measured by: 	Audited by: SD	Prototype Approval: 
Date: 05.05.31	Date: 05.05.31	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	